

Blue

Dart Aerospace Ltd.

Date: Monday, 17/11/2008 10:38:41 AM
User: Julie Dawson

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services
Job Number : 43474
Estimate Number : 10973
P.O. Number :
This Issue : 17/11/2008 **S.O. No.** :
Prsht Rev. : NC
First Issue : / / **Type** : CROSSTUBES
Previous Run : 43473
Written By :
Checked & Approved By : Jul 08.11.17
Comment : Est Rev:F 05.09.01 Add holes for compatibility with Bell
Skidtubes KJ/JLM
Est Rev:G 08-06-03 update as per DSI9415 (ECN1198) DD
verified by:ec
Est Rev:H 08-07-18 remove thread masking in step 12 DD
verified by:EC

Drawing Name : 206L AFT X-TUBE
Part Number : D206667203BL
Drawing Number : D206-667-243 REV B
Project Number : N/A
Drawing Revision :
Material :
Due Date : 15/12/2008 **Qty:** 1 **Um:** Each

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	DC	DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Photocopy bluefile and create labels as per PPP D206-667-203 CHG003

2.0	D206667203TRN	Crosstube Turning Detail
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Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

CROSSTUBE TURNING DETAIL

batch B-43530

AVM / MB 08-11-24

3.0	BENDING	BENDING MACHINE - SKIDTUBES
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Comment: BENDING MACHINE

Bend tube as per Dwg D206-667-243 using CNC bender program 206L-AF and Folio FT

4.0	QC15	DIMENSIONAL CHECK OF X-TUBES
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Comment: DIMENSIONAL CHECK OF X-TUBES

5.0	CROSSTUBES	CROSSTUBES RESOURCE 1
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Comment: LANDING GEAR RESOURCE 1

1-Drill pilot holes in tube using drill Jig DT8583 & DT8584 as per Dwg D206-667-243. Drill all (3) top holes.

2-Drill and Ream all holes in tube to finish size using drill Jig DT8583 & DT8584 as per Dwg D206-667-243

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 17/11/2008 10:38:41 AM
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Drawing Name: 206L AFT X-TUBE

Job Number: 43474

Part Number: D206667203BL

Job Number:



Seq. #:	Machine Or Operation:	Description :
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Check dimensions between holes on all four sides.

3-Flip tube and switch drilling Jigs from right to left, left to right. Locate Jigs off existing holes using "T" pins.

4-Drill pilot holes using drill Jig DT8583 & DT8584 as per Dwg D206-667-243. Drill only the top (2) holes.

5-Drill & ream the top (2) holes to finish size using drill Jig DT8583 & DT8584 as per Dwg D206-667-243

6-Drill Fwd rivet holes using drill Jig DT8789FWD as per Dwg D206-667-143. Note: Fwd side has 3x top holes.

7-Drill Aft rivet holes using drill Jig DT8789 as per Dwg D206-667-243.

8-C'sink holes as per Dwg D206-667-243.

9-Deburr & Inspect for surface damage. Repair damage within limits as per Dwg D206-667-243

10-Scribe part # and batch # using vibrating stylus as per Dwg D206-667-243
Inside of Cuff (Donot engrave on outside of tube)

Handwritten: D/MB 08/11/26

Handwritten: AWM 8-11-27

Handwritten: > D/MB 08/11-26

6.0 HAND FINISHING1

HAND FINISHING RESOURCE #1



Handwritten: AWM 8-11-27



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

7.0 QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

Handwritten: S 08/11/27 (P)

8.0 QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

Handwritten: S 08/11/27 (P)

9.0 OUTSIDE SERV.11

OUTSIDE SERVICE -CROSSTUBES



Handwritten: P/O: 7725 C208112020



Comment: Sub-Contracting OUTSIDE SERVICE -CROSSTUBES

10.0 PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Inspect for transit damage

Ensure copy of NDT results attached to work order.

Handwritten: P 8/12/08 (10)

W/O:		WORK ORDER CHANGES						
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Job Number: 43474

Part Number: D206667203BL

Job Number:



Seq. #:	Machine Or Operation:	Description :
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11.0

QC6

DIMENSIONAL CHECK

QC5



ml 08 12 04 (1)



Comment: Inspect for damage & ensure results are as per Dwg D206-667-103

12.0

SPRAY PAINTING

SPRAY PAINTING



Comment: SPRAY PAINTING

1-Prime inside and outside crosstube as per QSI 005 4.2 - GREY

109992

2-

-PAINT DELFLEET BLUE 110077

-CLEAR DELFLEET 109816

ml 08 12 04 (1)

13.0

QC14

INSPECT SPRAY PAINT



08-12-05 (1)



Comment: Inspect Spray Paint

Wrap in plastic bag to protect from scratches

14.0

D2873045

Nut Plate Assembly



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part number Description Batch

2 D2873-045 Nut Plate 42784

ml 08 12 11

15.0

D2873043

Nut Plate Assembly



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part number Description Batch

2 D2873-043 Nut Plate 41988

ml 08 12 11

16.0

MS20601AD4W10

RIVET



Comment: Qty.: 14.0000 Each(s)/Unit Total : 14.0000 Each(s)

Pick:

Qty Part number Description Batch

14 MS20601AD4W10 Rivet 110219

ml 08 12 11

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Job Number: 43474

Part Number: D206667203BL

Job Number:



Seq. #:	Machine Or Operation:	Description :
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17.0	CROSSTUBES	CROSSTUBES RESOURCE 1
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Comment: LANDING GEAR RESOURCE 1

1-Install nut plates as per Dwg D206-667-243.

ml 08 12 11

18.0	D3595075450	RUBBER CUSHION .75" x 4.50
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Comment: Qty.: 4.0000 Each(s)/Unit Total: 4.0000 Each(s)
RUBBER CUSHION .75" x 4.50

341108

RT 08-12-10

19.0	D28921	Support
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Comment: Qty.: 2.0000 Each(s)/Unit Total: 2.0000 Each(s)
Pick:

Qty Part number Description Batch
2 D2892-1 Support

43385

RT 08-12-10

20.0	MS2192022	Clamp(per MIL-DTL-8783C)
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Comment: Qty.: 4.0000 Each(s)/Unit Total: 4.0000 Each(s)
Pick:

Qty Part number Description Batch
4 MS21920-22 Clamp

108187

RT 08-12-10

21.0	SKIDTUBES 1	SKIDTUBESS RESOURCE 1
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Comment: LANDING GEAR RESOURCE 1

1-Install abrasion strips as per QSI 035 using DT8580. Note: (3) top holes should be facing up.

08-12-10

2-Install supports and clamps as per Dwg D206-667-243. Torque clamps to 80-100 in lb

ml 08 12 11 (1)

22.0	QC5	INSPECT WORK TO CURRENT STEP
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Comment: INSPECT WORK TO CURRENT STEP

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Part Number: D206667203BL

Job Number:



Seq. #:	Machine Or Operation:	Description :
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23.0	PACKAGING 1	PACKAGING RESOURCE #1
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Comment: PACKAGING RESOURCE #1
Pick Packing Kit

24.0	AN534A	Bolt
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Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)
Bolt
Batch: M109061

25.0	MS21042L5	Nut
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Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)
Nut
Batch: M109297

26.0	AN510A	Bolt
------	--------	------



Comment: Qty.: 10.0000 Each(s)/Unit Total : 10.0000 Each(s)
Pick:Packing Kit
Qty Part number Description Batch
10 AN5-10A Bolt M109282

27.0	AN532A	Bolt
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Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)
Pick:Packing Kit
Qty Part number Description Batch
4 AN5-32A Bolt M109282

28.0	AN960JD516	Washer
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Comment: Qty.: 18.0000 Each(s)/Unit Total : 18.0000 Each(s)
Pick:Packing Kit
Qty Part number Description Batch
18 AN960JD516 Washer M109282

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Job Number: 43474

Part Number: D206667203BL

Job Number:



Seq. #:

Machine Or Operation:

Description :

29.0

QC4

INSPECT 100% KITS FOR COMPLETENESS



Comment: INSPECT 100% KITS FOR COMPLETENESS

08/12/12 (1)

30.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPP D206-667-203

Location: _____

PPP Rev: _____

Rev D

SS 08/12/12 (40)

31.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08/12/12

Job Completion



U 08/12/12

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

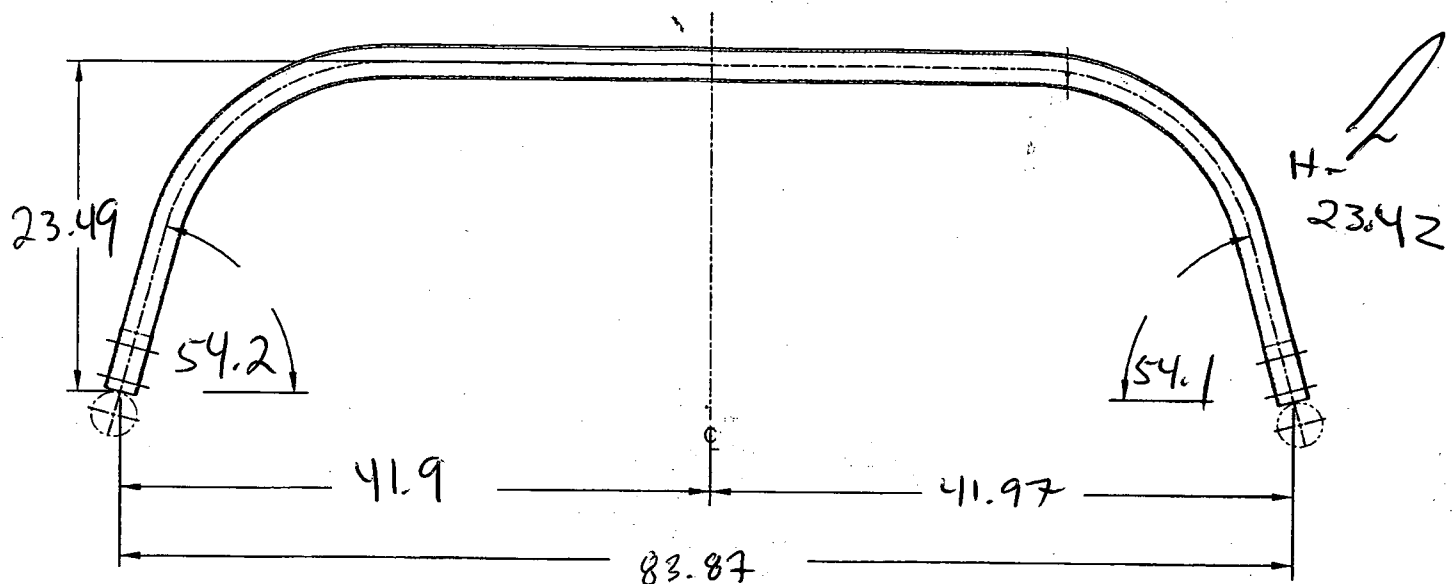
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE		Work Order: B-43474
Description: Crosstube High Lift (206L)		Part Number: D206-667-203
Inspection Drawing: D206-667-243	Rev: B	Page 1 of 1

Required Dimension	Min	Max
Height	23.46	23.58
1/2 Span	41.86	41.98
Angle	54	56
Total Span	83.72	83.96



Comments

QC15 Inspection	051012
Date	06.11.26

Rev	Date	Change	Revised by	Approved
A	07.02.06	New Issue	KJ/JM	[Signature]

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Item	Qty -243	Part Number	Description
1	X	D206-667-243	CROSSTUBE ASSEMBLY (206L HIGH AFT)
2	1	D6004-115	CROSSTUBE
3	2	D2873-043	NUT PLATE
4	2	D2873-045	NUT PLATE
5	2	D2892-1	SUPPORT
6	4	D3595-063-450	RUBBER CUSHION
7	4	MS21920-22	CLAMP
8	14	MS20601AD4W10	RIVET (OR NAS9302B-4-10)
9	A/R	MAGNOBOND 6398	ROCKWELL SPECIFICATION RBO-120-023 ADHESIVE (TEXTRON/BELL SPEC. 299- 947-100, TYPE II, CLASS 2 ADHESIVE)

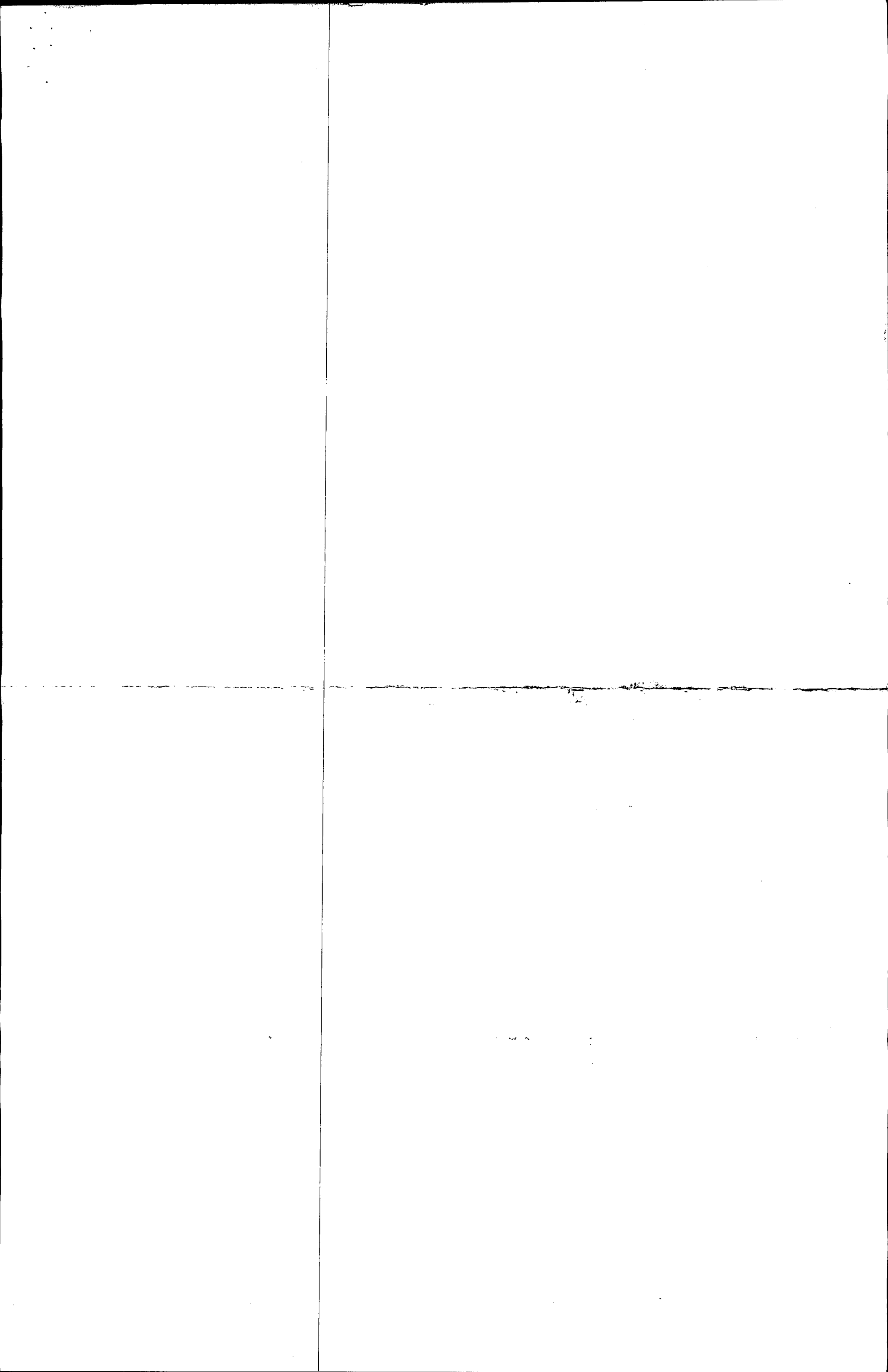
GENERAL NOTES:

- MATERIAL: MANUFACTURED FROM D6004-115
FINISHED LENGTH = 104.91±0.020
- FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
PRIME INSIDE AND OUTSIDE PER DART QSI 005 4.2
PAINT OUTSIDE PER DART QSI 005 4.2
- TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
- UNITS: INCHES UNLESS OTHERWISE NOTED.
- BREAK SHARP EDGES: 0.005 TO 0.010 MAX.
- IDENTIFICATION: SCRIBE DART PART NUMBER "D206-667-243" AND BATCH NUMBER ON INSIDE OF CUFF USING VIBRATING STYLUS.
- WEIGHT: 21.9 lbs
- PART IS SYMMETRIC ABOUT CENTERLINE.
- RUN CUTTER OFF PART WHERE INDICATED. BLEND OUT EDGE LONGITUDINALLY, TRANSITION SHOULD BE SMOOTH.
- BEND PROGRESSIVELY WITH A MINIMUM OF 8 PASSES. MAXIMUM TUBE FLATTENING DUE TO BENDING IS 6% BASED ON O.D.
- LIQUID PENETRANT INSPECT OUTSIDE SURFACE OF CROSSTUBE PER QSI 038.
- INSTALL D2892-1 SUPPORT USING 0.03" TO 0.06" THICK LAYER OF MAGNOBOND 6398 PER QSI 015. LET CURE FOR 12 HOURS AFTER INSTALLATION AND PRIOR TO PACKAGING.
- INSTALL MS21920-22 CLAMPS WITH D3595-063-450 RUBBER CUSHIONS TO SECURE THE D2892-1 SUPPORT ON TOP SIDE OF THE CROSSTUBE. ENSURE CLAMP MECHANISMS ARE LOCATED ON CROSSTUBE SUPPORTS.
- EXTREME CARE MUST BE TAKEN TO PROTECT THE OUTSIDE SURFACE OF THE TUBE. THE OUTSIDE SURFACE MUST BE SMOOTH AND FREE FROM SURFACE DEFECTS SUCH AS SCRATCHES, NICKS, OR DENTS. DEFECTS UP TO 0.005" MAY BE BLENDED OUT LONGITUDINALLY. CIRCUMFERENTIAL GRIND MARKS ARE UNACCEPTABLE.
- TORQUE CLAMPS 80 TO 100 IN-LB. ENSURE AT LEAST 1.5 THREADS ARE SHOWING IN SAFETY AND THAT NUT HAS NOT BOTTOMED-OUT AFTER TORQUING.

RELEASED
08/11/06

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER NO. 43474

C	REVISE GENERAL NOTES/PART LIST (ZN D7-1); REORGANIZED VIEWS AND REFORMATTED DRAWING TO CURRENT STANDARDS. D3595-063-450 WAS D2856-400-773 (ZN D6-2 & A5-2); REMOVED REF. & ADD TOLERANCES (ZN 4-3, C5-3, D3-3); RELOCATED FLAG #6 (ZN A8-3) PER NCR 210; MOVED TURNING DETAIL & UPDATED TOLERANCE TO SHEET 4.	RF	08.11.06
B	ADD HOLES AND NUT PLATES FOR COMPATABILITY WITH BHT/AA SKUDTUBES	PH	05.07.26
A	NEW ISSUE	CP	00.11.17
REV.	DESCRIPTION	BY	DATE
DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF	DRAWING NO.	REV. C
CHECKED	RF	D206-667-243	SHEET 1 OF 4
MFG. APPR.	RF	TITLE	SCALE
APPROVED	RF	CROSSTUBE ASS'Y (206L HIGH AFT)	NTS
DE APPR.	RF	COPYRIGHT © 2000 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	
DATE	08.11.06		



8

7

6

5

4

3

2

1

D

D

C

C

B

B

A

A

12 D2892-1 SUPPORT
2 PL

15 MS21920-22 CLAMP
4 PL

C

13

D3595-063-450
RUBBER CUSHION
4 PL, (UNDER CLAMP)

B

10.03

B

A4-2

D206-667-603

B7-2

C

B2-2

C

D206-667-243
ASSEMBLY DETAIL
(VIEW LOOKING FWD)

RELEASED
2/11/74

D2873-043
NUT PLATE

MS20601AD4W10
RIVET, 4 PL

D2873-045
NUT PLATE

MS20601AD4W10
RIVET, 3 PL

90°
REF

VIEW A-A:
CUFF DETAIL
SCALE 4X

13 15
MS21920-22 CLAMP REF

12
D2892-1 SUPPORT REF

C

D3595-063-450
RUBBER CUSHION
REF

FWD

D5-2 SECTION B-B
SCALE 5X

D2873-045
NUT PLATE

MS20601AD4W10
RIVET, 3 PL

D2873-043
NUT PLATE

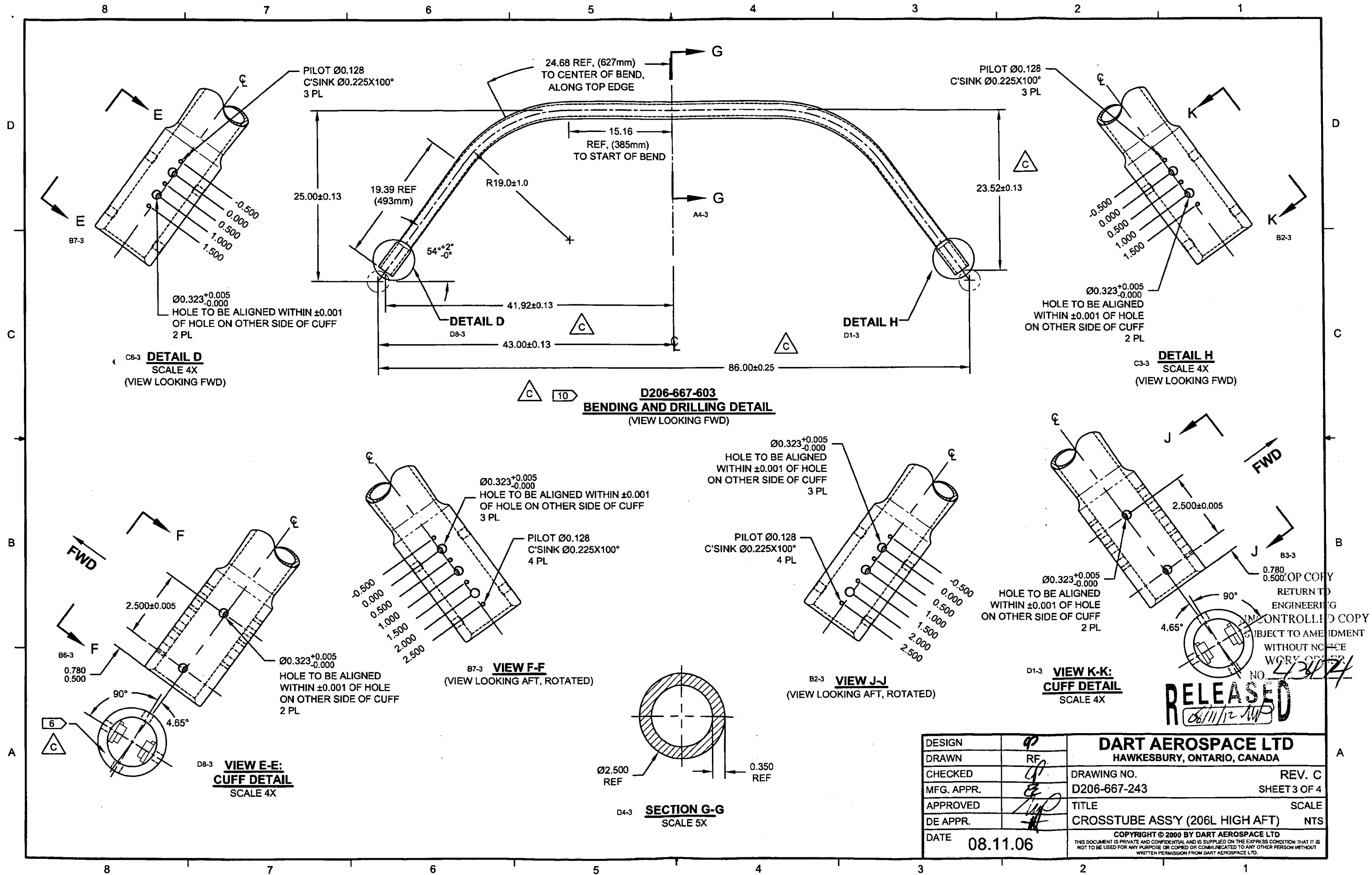
MS20601AD4W10
RIVET, 4 PL

90°
REF

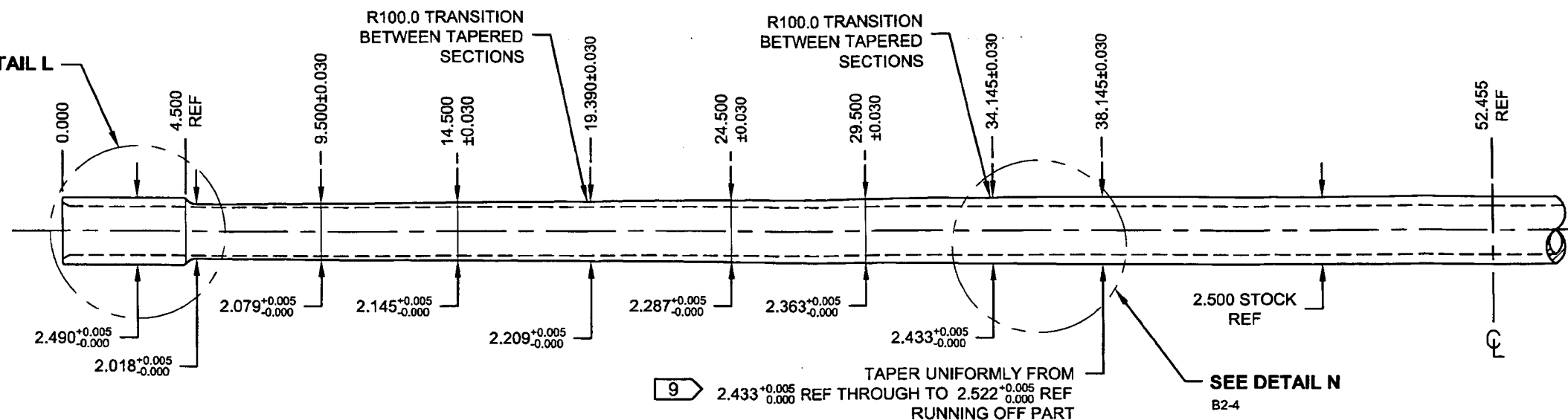
VIEW C-C:
CUFF DETAIL
SCALE 4X

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SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 43474

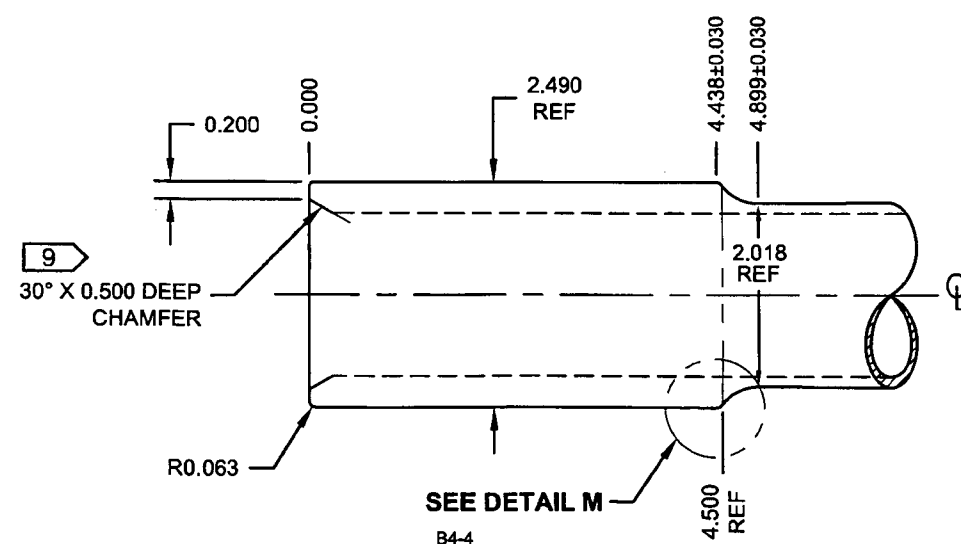
DESIGN	97	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF	DRAWING NO.	REV. C
CHECKED	JP	D206-667-243	SHEET 2 OF 4
MFG. APPR.	JP	TITLE	SCALE
APPROVED	JP	CROSSTUBE ASS'Y (206L HIGH AFT)	NTS
DE APPR.	JP	COPYRIGHT © 2000 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	
DATE	08.11.06		



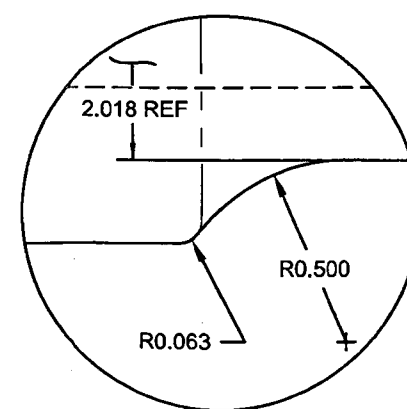
SEE DETAIL L
B7-4



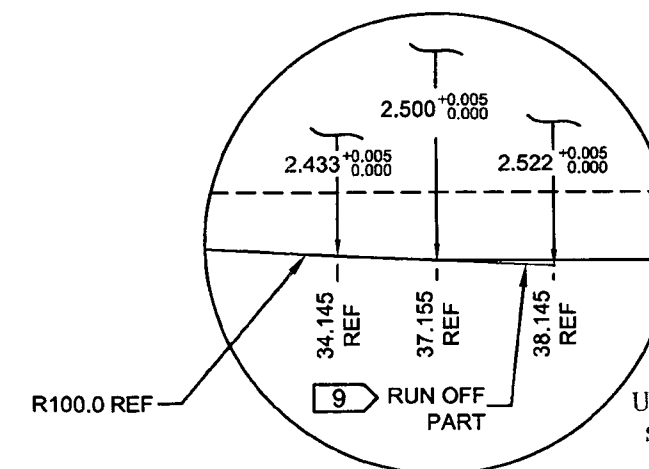
TURNING DETAIL



DETAIL L: CROSSTUBE CUFF
NOT TO SCALE



DETAIL M: CUFF TRANSITION
NOT TO SCALE



DETAIL N: TAPER RUN-OFF
NOT TO SCALE

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 43474

RELEASED
08/11/12

DESIGN	92	DART AEROSPACE LTD	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. C
MFG. APPR.		D206-667-243	SHEET 4 OF 4
APPROVED		TITLE	SCALE
DE APPR.		CROSSTUBE ASS'Y (206L HIGH AFT)	NTS
DATE	08.11.06	COPYRIGHT © 2000 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

Date: Wednesday, 19/11/2008 9:00:38 AM
User: Julie Dawson

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services
Job Number : 43474
Estimate Number : 10973
P.O. Number :
This Issue : 19/11/2008 S.O. No. :
Prsht Rev. : NC
First Issue : 17/11/2008 Type : CROSSTUBES
Previous Run : 43473
Written By :
Checked & Approved By :
Comment : Est Rev:F 05.09.01 Add holes for compatibility with Bell
Skidtubes KJ/JLM
Est Rev:G 08-06-03 update as per DSI9415 (ECN1198) DD
verified by:ec
Est Rev:H 08-07-18 remove thread masking in step 12 DD
verified by:EC

Drawing Name : 206L AFT X-TUBE
Part Number : D206667203BL
Drawing Number : D206-667-243 REV B
Project Number : N/A
Drawing Revision :
Material :
Due Date : 15/12/2008 Qty: 1 Um: Each

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0

DC

DOCUMENT CONTROL



JUL 08-12-05



Comment: DOCUMENT CONTROL

Photocopy bluefile and create labels as per PPP D206-667-203 CHG003

2.0

D206667203TRN

Crosstube Turning Detail



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
CROSSTUBE TURNING DETAIL
batch _____

3.0

BENDING

BENDING MACHINE - SKIDTUBES



Comment: BENDING MACHINE

Bend tube as per Dwg D206-667-243 using CNC bender program 206L-AF and Folio FT: _____

Job Completion

